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D2435
Job Sheet 181017



Part No: D2435

Part Name: Bearpaw

Job Qty: 6 ea



Part Weight: 0 lbs

Job Created: 7/19/18

Due Date: 8/1/18

Type: Stock

Note: DWG REV E1

Ship Via:

Status: Scheduled

Job Tracking No:

Priority: Medium

Created By: Jason Leroux

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		8/1/18	0.00	0.00	Start Up Container		
120	Waterjet	6 pcs		8/1/18	0.00	1.00	Waterjet 2 OMAX		
130	CNC Vertical Machining	6 pcs		8/1/18	0.41	6.09	HAAS 1		
150	QC	6 pcs		8/1/18	0.00	0.00	QC8		
151	Packaging	6 pcs		8/1/18	0.00	0.00	Packaging3		
190	QC21-SA	6 Ea		8/1/18	0.00	0.00	QC21		

Part Op 120 - CUT BLANK AS PER FILE D2435
Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	19.2000 sf (3.2 ea)	90-Start up Operation	8045595

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	19	1,173	0

Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053	0.065"
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	45° Angle
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470	5.498
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170	0.206
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	0.250 Radius
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.244
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595	0.620
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240	0.250
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	45° Angle
10	Bearpaw	0.375Inches ± 0.010	0.385 0.365	0.370
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970	19.00
12	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	0.943
13	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	0.258 Diameter
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	0.926 Diameter
15	Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300	0.310
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345	0.378
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345	7.383
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240	4.250
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970	2.016
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990	9.00
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720	15.750

Plex 7/19/18 1:13 PM dart.leroux.jason

MD 14 Jun 2019

DQA: _____ Date: _____

QA Closed: _____ Date: 18/08/13

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: 181017		DISPOSITION		AGAINST DEPARTMENT/PROCESS				MRB (QS1042) Approval							
Part No. D2435		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube Machining ☒ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐					
NCR No. 19-7129		Suspected Unapproved		QTY Effective: 1											
Date: 18-08-13		Step #: 130													
Description Work Order Deviation				Disposition				Completed By: S. J. 13							
Chamfers are out of tol. ↳ Dimension Suppose to be 0.063" +.035" - .000" ↳ Chamfer are 0.105" in one Spot, Machinist forgot to instal Bolts for last op. Re. No Refeferance of JSTN before JSTN's Reverification				SEAP + JSTN Replaced by 41				Lead hand / Supervisor Approval Verification: D. J. 18-08-13							
								QC / QA Coordinator Approval: h. 18-08-13							
								Sub: 13							
Root Cause				FAULT CATEGORY											
Environment: ☐ No Re-verification ☒				Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐				Positioned Wrong ☐							
Design: ☐ Operator ☒				Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐			
Equip/Tooling: ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐												Outside Dimensions ☐			
Handling/Pre: ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐												Over/Under tolerance ☐			
Material: ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐												Part Incorrect ☐			
Tribal Knowledge: ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐												Part Lost/Missing ☐			
LOA: ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐												Part Moved ☒			
Substation: ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐												Drawing ☐			
Past Expiry Date: ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐												Misread ☐			
Misidentified: ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐												Turning Sequence ☐			
OTHER: ☐															